

**WHAT IS CLAIMED IS:**

**1. A magnetic tape cartridge comprising:**

an opening through which a magnetic tape is drawn out, the opening  
5 being provided in part of a sidewall of a cartridge case across a lower half and an  
upper half of the cartridge case; and  
a slide door that slides along the sidewall provided with the opening to  
open and close the opening,  
wherein at least one of a lower half portion and an upper half portion of  
10 the sidewall is provided with a holding concave portion that receives a front end  
portion of the slide door when the opening is closed.

**2. A method of assembling a magnetic tape cartridge comprising the steps  
of:**

15 providing an opening through which a magnetic tape is drawn out in part  
of a sidewall of a cartridge case across a lower half and an upper half of the cartridge  
case;

mounting a slide door that opens and closes the opening between guide  
portions each provided in the lower half and the upper half, while stressing the slide  
20 door with a spring member toward a position in which the opening is closed,

wherein the mounting step includes:

mounting the slide door stressed with the spring member toward the  
position in which the opening is closed by fitting a lower edge of the slide door into  
the guide portion of the lower half;

keeping a mounting position of the slide door by holding an end of the slide door facing a direction in which the slide door moves to close the opening with a chuck device; and

combining the upper half with the lower half.

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3. A method of assembling a magnetic tape cartridge according to claim 2, wherein the end of the slide door facing the direction in which the slide door moves to close the opening is anchored with a stopper after the upper half is combined with the lower half, and the stopper is removed from the slide door after the slide door is

10 released from the chuck device.

4. A method of assembling a magnetic tape cartridge according to claim 2, wherein each guide portion provided in the lower half and the upper half is comprised of any one of a guide groove, a rib provided between the slide door and upper and lower edges of the opening in the sidewall in such a manner as to slidably hold the slide door, and a plurality of projections.

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5. A method of assembling a magnetic tape cartridge comprising the steps of:

20 providing an opening through which a magnetic tape is drawn out in part of a sidewall of a cartridge case across a lower half and an upper half of the cartridge case;

mounting a slide door that opens and closes the opening between guide portions each provided in the lower half and the upper half, while stressing the slide

25 door with a spring member toward a position in which the opening is closed,

wherein the mounting step includes:

mounting the slide door stressed with the spring member toward the position in which the opening is closed by fitting a lower edge of the slide door into the guide portion of the lower half;

holding the slide door by pressing an appropriate spot of an end of the slide door facing a direction in which the slide door moves to close the opening so that the end of the slide door facing the direction in which the slide door moves to close the opening is prevented from rising out due to stress imposed by the spring member; and

combining the upper half with the lower half.

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6. A method of assembling a magnetic tape cartridge according to claim 5, wherein the appropriate spot for pressing the end of the slide door facing the direction in which the slide door moves to close the opening to hold the slide door is located above a straight line so extending as to join a contact point of one end of the spring member with the lower half and a contact point of the other end of the spring member with the slide door.

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7. A method of assembling a magnetic tape cartridge according to claim 5, wherein each guide portion provided in the lower half and the upper half is comprised of any one of a guide groove, a rib provided between the slide door and upper and lower edges of the opening in the sidewall in such a manner as to slidably hold the slide door, and a plurality of projections.

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8. An assembly supportive device which guides a distal end of a spring support rod onto a support rod receiving block provided on a lower half of a cartridge case when a slide door for opening/closing an opening through which a magnetic tape

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of a magnetic tape cartridge is drawn out is fitted in the lower half of the cartridge case, a proximal end of the spring support rod being projected from the slide door, around which spring support rod a compression coil spring is wound, the assembly supportive device comprising:

5                   a guide member having a V-shaped groove that receives the distal end of the spring support rod; and

                  a positioning device capable of moving the guide member from a retraction position outside the lower half to a use position over the support rod receiving block on the lower half,

10                  wherein the guide member is formed with a slit so provided as to cut through a bottom of the V-shaped groove partway from one end.